

Date: Tuesday, 31/03/2009 7:18:20 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT WELDMENT ASS'Y
Job Number :	46725		
Estimate Number :	10675		
P.O. Number :		Part Number :	D3443041
This Issue :	31/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3443 REV. B
First Issue :	/ /	Project Number :	N/A
Previous Run :	46128	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :		Due Date :	07/04/2009
Comment :	EST REV. A 08.11.17	Qty:	4
	NEW ISSUE	Um:	Each
	EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34431	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3443-1	lug

Batch

B46143 = 4x SP 09.03.31

2.0	D34435	Tubing
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3443-5	Tubing

Batch

B46142 = 4x SP 09.03.31

3.0	D34531	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3453-1	Clevis

Batch

B46144 = 4 SP 09.03.31

4.0	238805	SS DOWEL PIN 3/4" LONG
-----	--------	------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
2	238-805	SS DOWEL PIN 3/4" LONG

Batch

M1050378 SP 09.03.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Job Number: 46725

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3443

SP 09.03.31

4X

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.03.31

4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/01

4

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M1109391

START TIME:

9:05

OVEN TEMPERATURE:

400°

FINISH TIME:

9:35

BL 09-04-3

4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

63215K32

Spherical Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 63215K32

Spherical Bearing

M111278

SB 09/04/06

4

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotates smoothly

FF 09-04-06

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 46725

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 09/04/06 (4)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 198A

PC4/4/6 (4)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/07

Job Completion

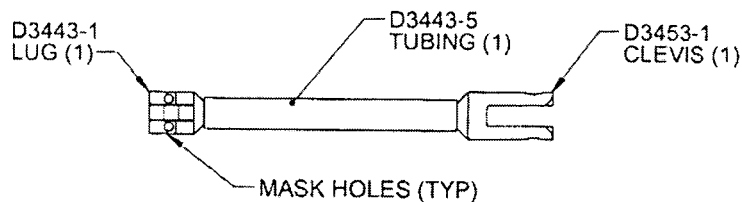


MF
09-04-06

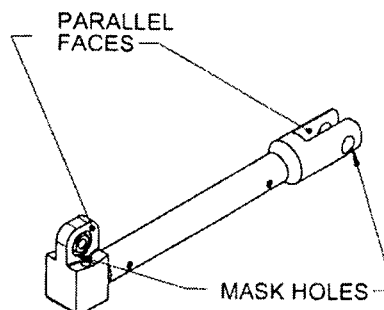
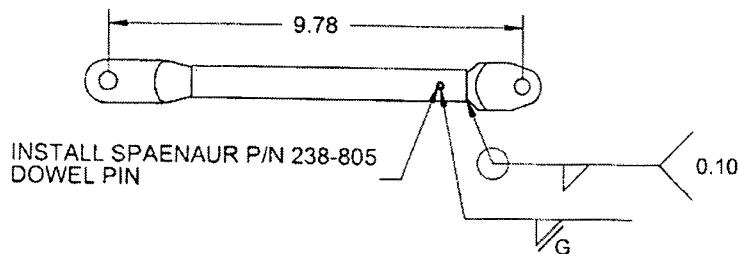
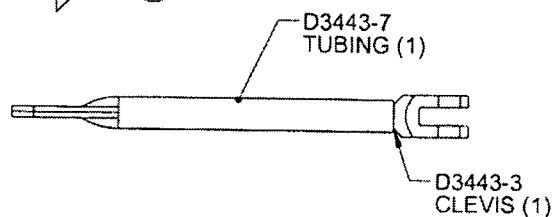
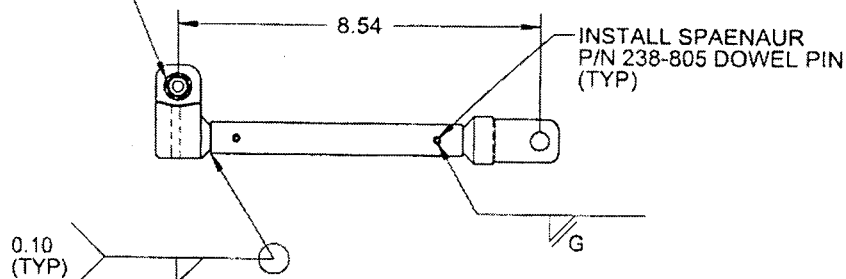
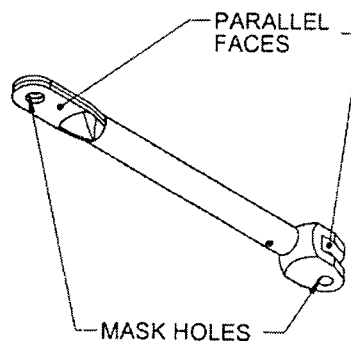
DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED

05.12.05 *[Signature]*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041***w/o 11/7/25***D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

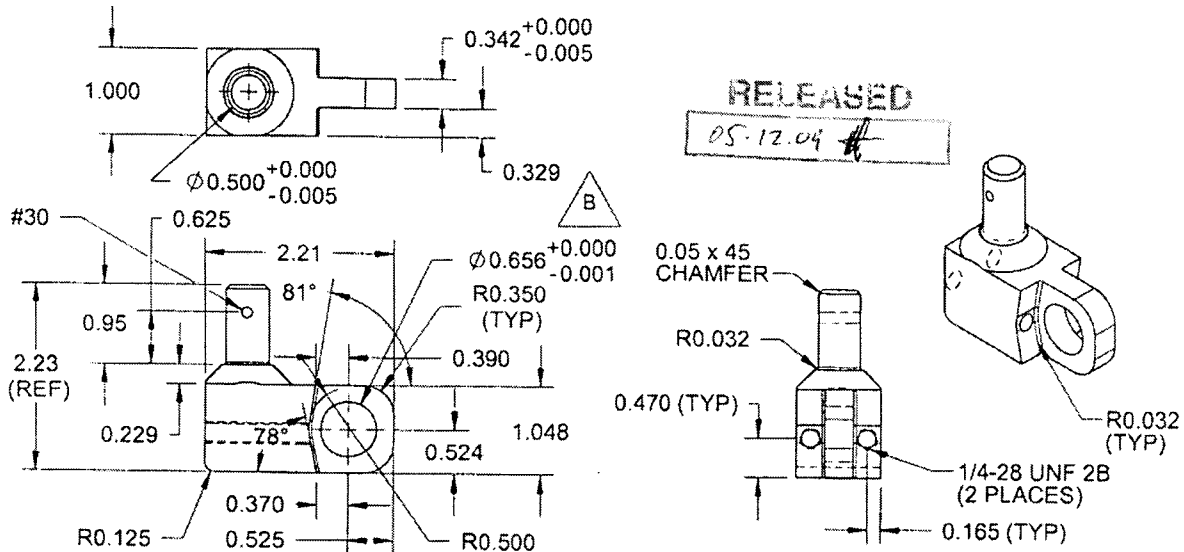
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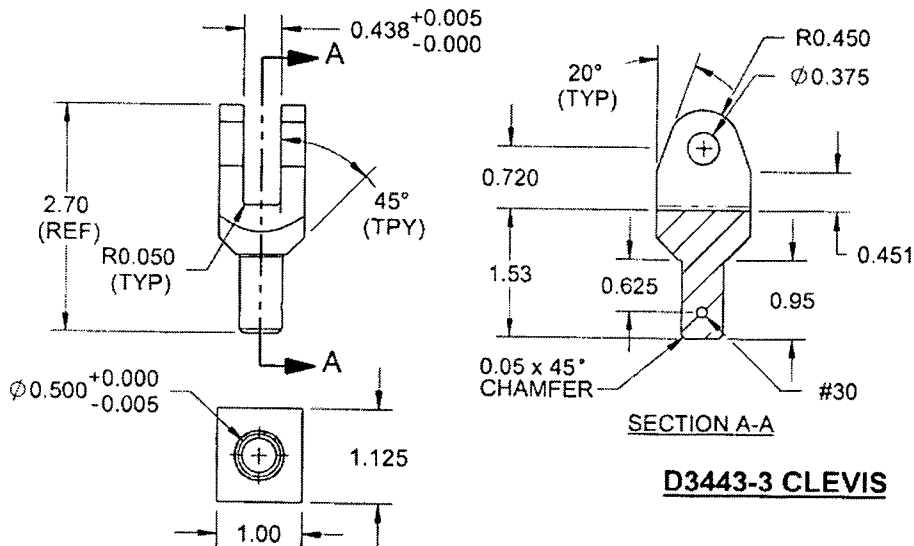
8.576
- .219
8.321
500
8.821

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY	SHEET 2 OF 3 SCALE 1:2	

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 CLEVIS****D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\phi 0.210^{+0.005}_{-0.010}$

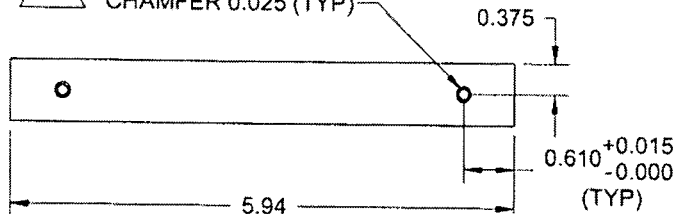
1.05

**D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

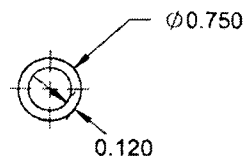


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

**D3443-5 TUBING**

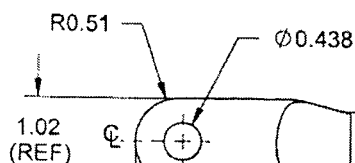
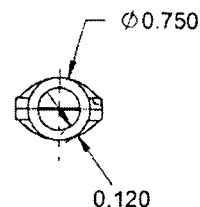
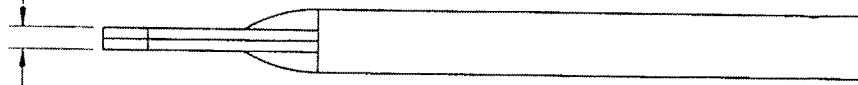
RELEASED

05.12.05



46725

$0.260^{+0.000}_{-0.030}$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025

1.02
(REF)

0.55

1.10 FLATTEN END

8.47

0.375

$0.610^{+0.015}_{-0.000}$

D3443-7 TUBING**D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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